



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D2332-041
Job Sheet 174133



Part No: D2332-041

Job Qty: 5 ea

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	4/24/18	4/24/18	0.00	0.00	Start Up Small Fab		FF
100	Small Fab	5 pcs	4/24/18	4/24/18	0.32	1.56	Small Fab		FF
110	Brake NC	5 pcs	4/24/18	4/24/18	0.00	0.57	Brake NC 3		FF
120	Small Fab	5 pcs	4/24/18	4/24/18	0.00	1.56	Small Fab		FF
130	QC	5 pcs	4/24/18	4/24/18	0.00	0.00	QC5		38
140	Large Fab	5 pcs	4/24/18	4/24/18	0.00	1.25	Large Fab 1		9-88 DX 18/10/18
150	QC	5 pcs	4/24/18	4/24/18	0.00	0.00	QC9		15-04-11
160	QC	5 pcs	4/24/18	4/24/18	0.00	0.00	QC5		PD 10-04-11
170	Small Fab	5 pcs	4/24/18	4/24/18	0.00	1.56	Small Fab		DEF 18-05-02
180	QC	5 pcs	4/24/18	4/24/18	0.00	0.00	QC5		38
190	Packaging	5 pcs	4/24/18	4/24/18	0.00	0.00	Packaging3	ST367	MAY 08 2018
200	QC21-SA	5 Ea	4/24/18	4/24/18	0.00	0.00	QC21		21 MAY 08 2018

Part Op 100 - 1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332. 2- Cut D2332-11 using 1/2" S.S tubing 7.735" long. 3- Descriptions: Deburr.

110 - Punch and form D2332-11 to lenght as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube

140 - Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding***** S.S Rod batch: M136185

170 - 1- Tumble 2- Assemble as per dwg D2332

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R.250	304 SS Round bar .250	.5000 ft (.1 ea)	90-Start up Operation	M135249
M304TR1.000W.049	304 Round Tube 1.00 X .049W	2.1500 ft (.43 ea)	90-Start up Operation	M125250
M304TR0.500W.035	304 Round Tube .500 X .035W	6.2500 ft (1.25 ea)	110-Brake NC	SG 34343
AN4-4A	Bolt	5 Ea (1 ea)	170-Small Fab	30446215
MS21042L4	Nut	5 Ea (1 ea)	170-Small Fab	5054118
NAS1149D0416J	Washer	15 Ea (3 ea)	170-Small Fab	M131511



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Container No: S056357



Part: D2332-041

Job No: 174133

Serial No/Batch: S056357

Revision:

Inspector:

Date: 03/29/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R.250	1	18	0
	M304TR1.000W.049	2	13	0
110-Brake NC	M304TR0.500W.035	6	102	0
170-Small Fab	AN4-4A	5	70	0
	MS21042L4	5	3,511	0
	NAS1149D0416J	15	3,244	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches ± 0.030	5.030 4.970		
2	Lid Prop Assembly	1.250Inches ± 0.010	1.260 1.240		
3	Lid Prop Assembly	6.690Inches ± 0.010 6.74	6.700 6.680		

Plex 3/12/18 9:59 AM Dart.Gagnon.Michelle